

Date: Friday, 7/4/2008 12:49:26 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 40287	
Estimate Number : 12722	
P.O. Number :	Part Number : D353615
This Issue : 7/4/2008 S.O. No. :	Drawing Number : D3536 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 33964	Material :
Written By :	Due Date : 7/11/2008 Qty: 20 Um: Each
Checked & Approved By : <u>4028 07 07</u>	
Comment : Est Rev: A New Issue 07-02-14 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
-----	------------	----------------------



Comment: Qty.: 1.0340 sf(s)/Unit Total : 20.6808 sf(s)

NEOPRENE SHEET 0.063

Batch: 107656 HB 8-7-16

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: AProg Rev: AHB 8-7-16

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

HB 8-7-16

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

counters

Comment: SECOND CHECK

50067/16 (x26)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

SP

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FF138/07/16200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:49:26 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 40287

Part Number: D353615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/17 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	40287
<b>Description:</b> Gasket		<b>Part Number:</b>	D3536-15
<b>Inspection Dwg:</b> D3536 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15	X			
35.65	+/-0.030	35.65	X			
33.65	+/-0.030	33.65	X			
30.15	+/-0.030	30.15	X			
24.90	+/-0.030	24.90	X			
19.65	+/-0.030	19.65	X			
14.40	+/-0.030	14.40	X			
9.15	+/-0.030	9.15	X			
5.65	+/-0.030	5.66	X			
3.90	+/-0.030	3.90	X			
8.00	+/-0.030	8.00	X			
16.00	+/-0.030	16.00	X			
24.00	+/-0.030	24.00	X			
0.30	+/-0.030	302	X			
0.30	+/-0.030	303	X			
1.89	+/-0.030	1.901	X			
Ø0.19	+0.005/-0.001	.192	X			

<b>Measured by:</b>	LB	<b>Audited by:</b>	S	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	8-7-16	<b>Date:</b>	28/07/16	<b>Date:</b>	N/A

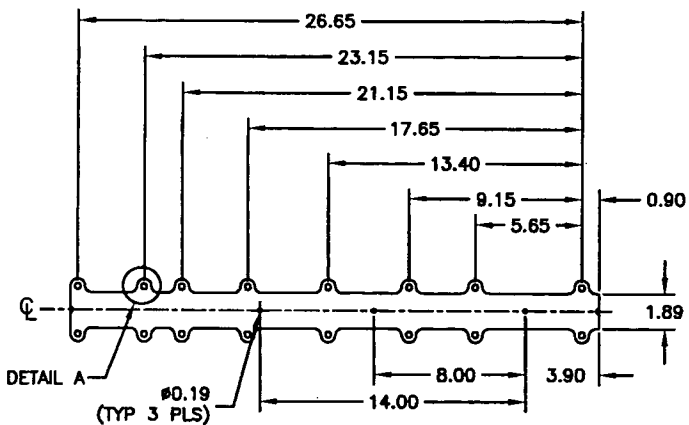
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	JA

**DART**

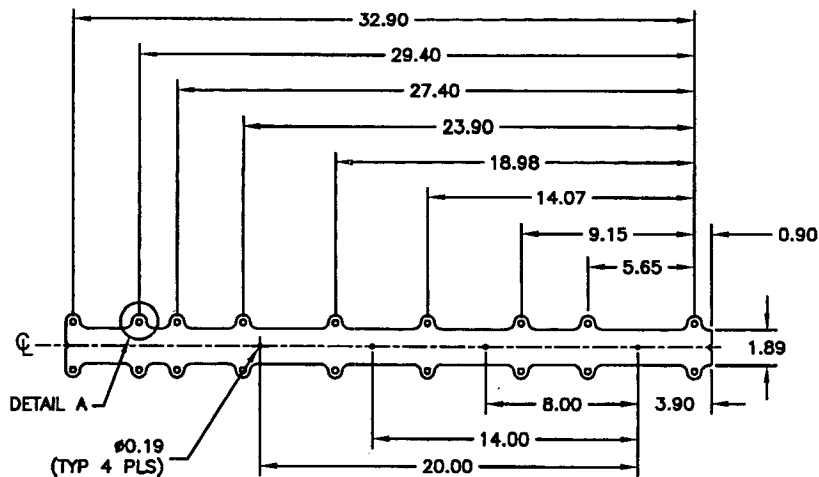
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09.02.12-11

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10



**D3536-11 GASKET**



**D3536-13 GASKET**

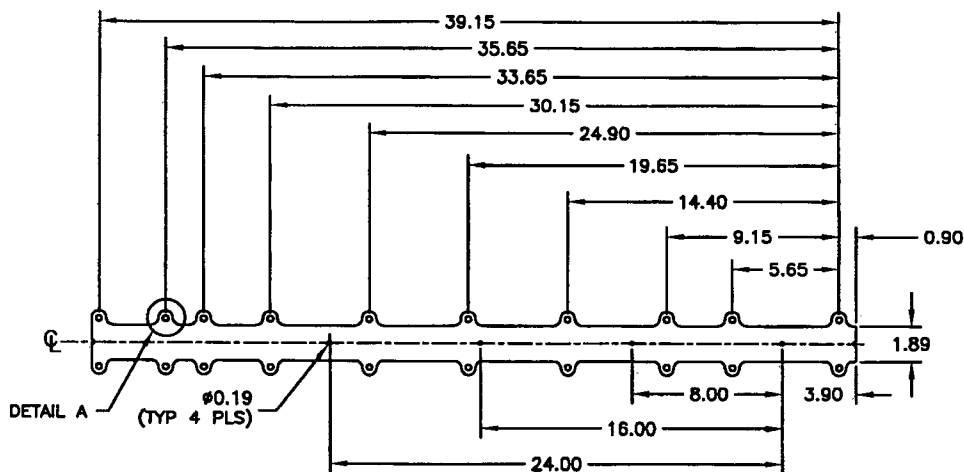
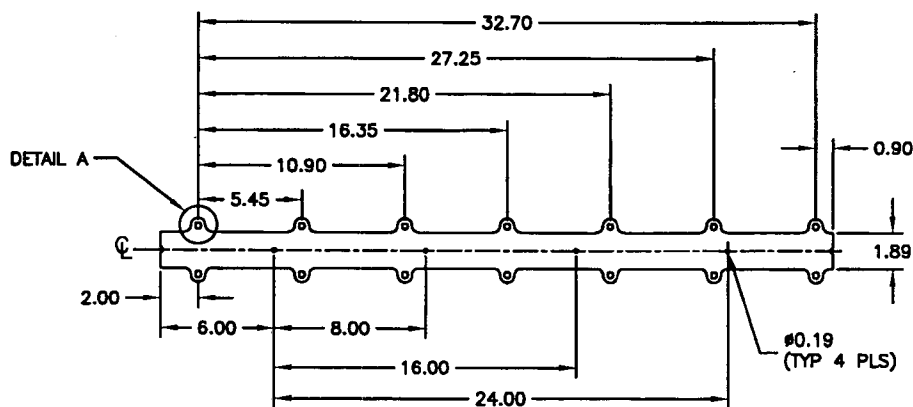
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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WORK ORDER  
NO. 70087

**DART**

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE US
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	
		GASKET		

SCALE  
1:10RELEASED  
070212**D3536-15 GASKET****D3536-21 GASKET****NOTES**

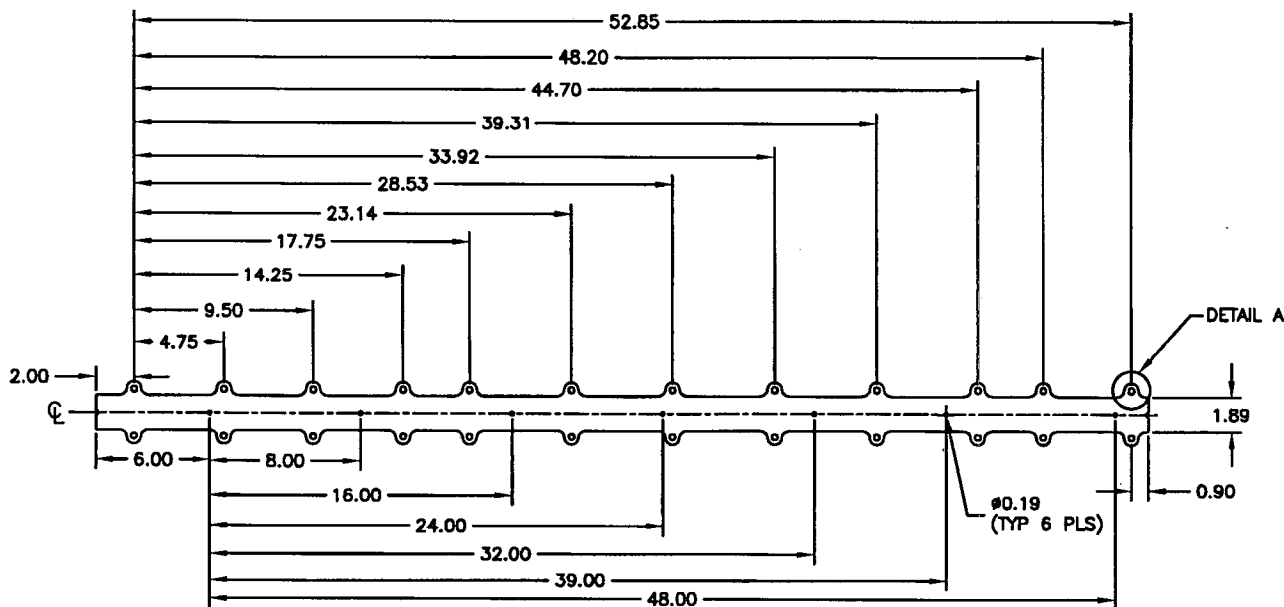
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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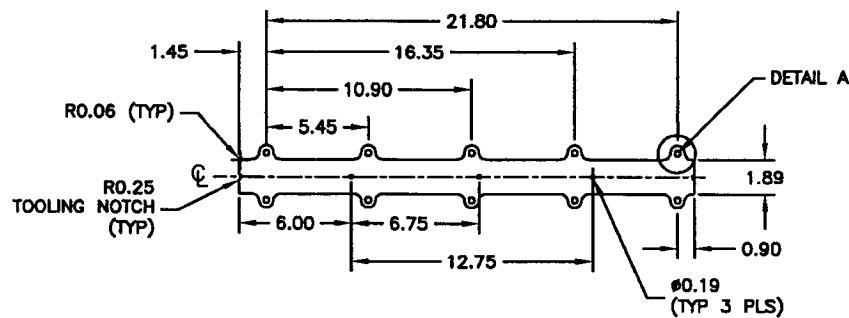
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 3 OF 6
				SCALE
				1:10

RELEASED  
07.02.12



**D3536-23 GASKET**



**D3536-25 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16" THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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WORK ORDER  
NO. 10281

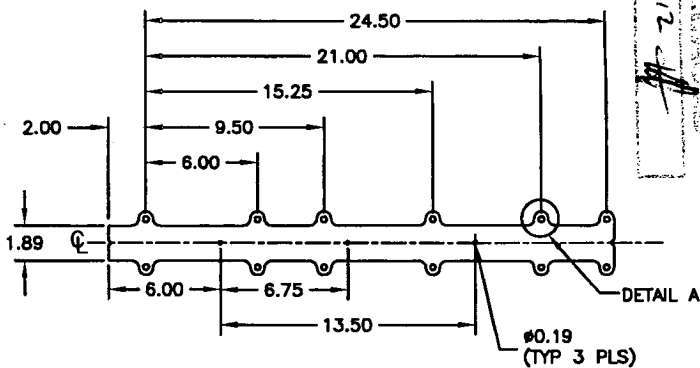




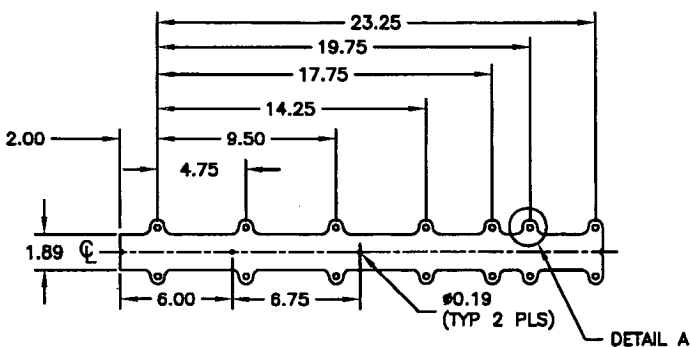
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 4 OF 6
				SCALE
				1:10

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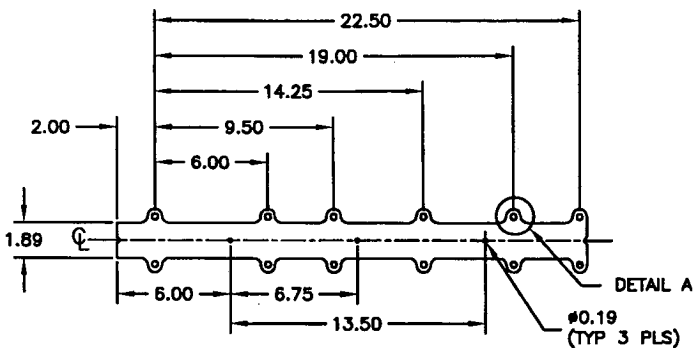
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**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

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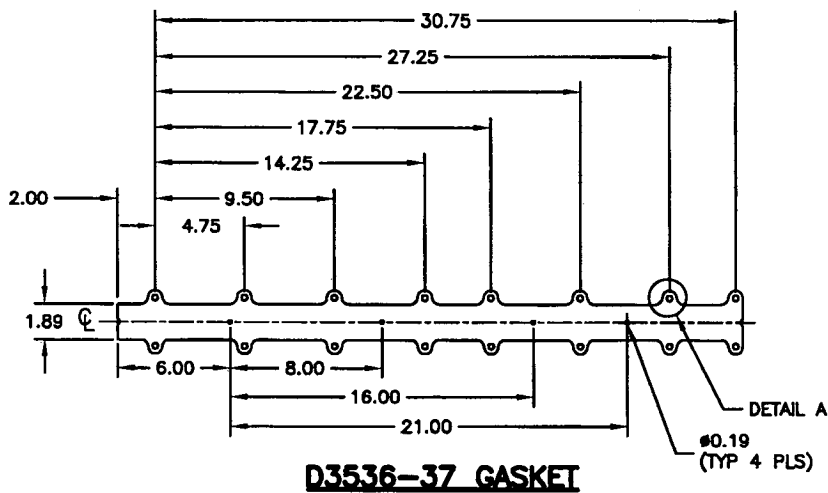
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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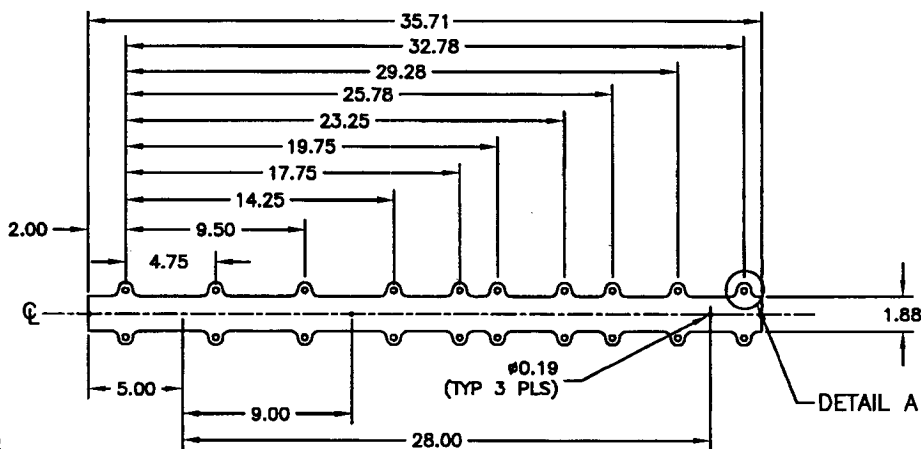
**DART**

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.	REV. A
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	
DATE	06.10.25	TITLE	D3536	DRAWING NO.	SHEET 5 OF 6
			GASKET		SCALE 1:10

07.02.12  
07.02.12  
07.02.12



**D3536-37 GASKET**



**D3536-39 GASKET**

**NOTES**

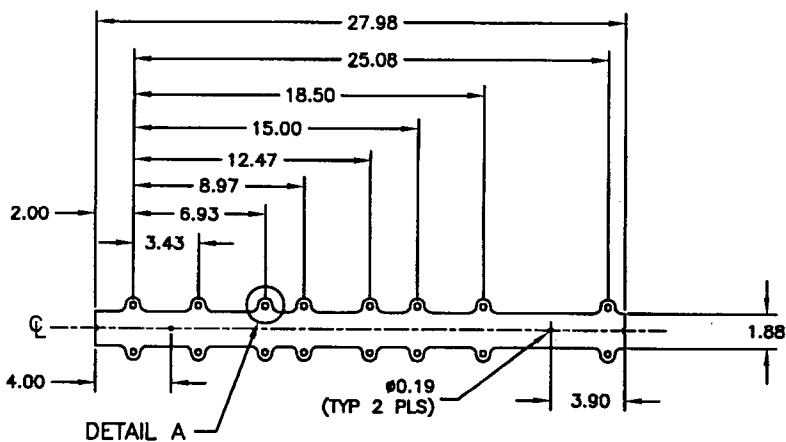
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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WORK ORDER

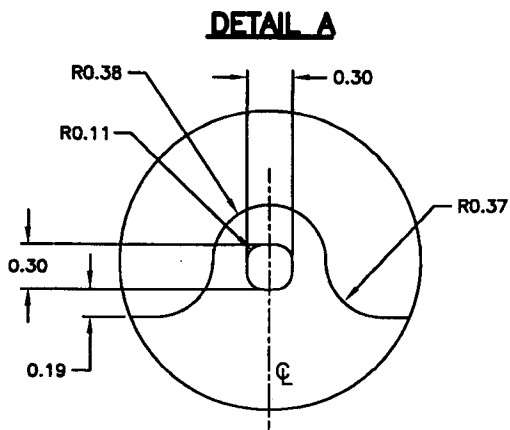


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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 6 OF 6
				SCALE 1:10

076212 CB



D3536-41 GASKET



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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